

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000301**Date Inspected:** 24-Jul-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Mary Madere is present at the Ironworkers Apprenticeship Training Facility as requested by ABF for the continuing purpose of witnessing Procedure Qualification Record (PQR) tests.

On this date, the QA Inspector observed the following personnel present: Smith-Emery Company's Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representative Mr. Rick Clayborn and welder Mr. Dan Gordon.

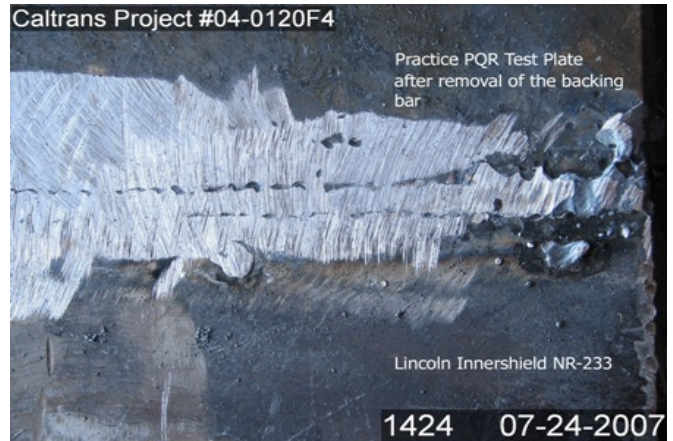
The QA Inspector observed Quality Control (QC) Representative Mr. Michael Johnson as he performed ultrasonic testing (UT) on the completed PQR test plate identified as ABF-002-2A. At the completion of testing, Mr. Johnson informed the QA Inspector that UT of the identified PQR test plate is acceptable.

On this date, ABF Representative Mr. Tommy Gibson picked up eight completed PQR test plates for delivery to Consolidated Engineering Laboratories (CEL) for radiographic testing. The PQR test plates delivered to CEL on this date are as follows: ABF-PQR-002-2A, ABF-PQR-026-1, ABF-PQR-026-2, ABF-PQR-025-1, ABF-PQR-025-2, ABF-PQR-002-1D, ABF-PQR-001-1A and ABF-PQR-001-2D.

The QA Inspector observed Mr. Dan Gordon as he welded several practice test plates to determine root pass settings for the next PQR which will be identified as ABF-PQR-004-1. Mr. Gordon welded 125 millimeter sections of these practice test plates using various parameters and travel speed, then removed the backing bar to evaluate the weld. Mr. Gordon used ten practice test plates and did not begin a PQR on this date.

WELDING INSPECTION REPORT

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Summary of Conversations:

As stated above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Madere,Mary

Quality Assurance Inspector

Reviewed By: Mertz,Robert

QA Reviewer